

Work Order ID 136313***136313***

Page 1

Friday, November 27, 2015 3:08:23 PM

Item ID: D350-822-011 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: PA100 PUREair System for AS350/EC130
Start Date: 9/2/2015 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 9/3/2015 Req'd Qty: 1.00 ***1*** Customer: CPALL01
Reference: RMA RA111870

Approvals: Process Plan: MF Date: 15-11-27 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D350-822	D								

100

0.00

100

QC

Quality Control

Memo

INSPECT RA 111870
D350-822-011 X 1 B121720

CUSTOMER RETURNED PURE AIR KIT THAT WAS USED FOR DISLAY
ONLY

DURING INSPECTION, WAS FOUND:

- DAMAGE ON QB21304
- NUTS ON D4961-041 DON'T HAVE HOLES FOR LOCK WIRE
- REST OF KIT IS COMPLETE
- SCRAP D4961-041 X 1 B11961 AND REPLACE

With authorization and supplied parts from PALL replace QB21304 as showed
on email

Drill out rivet QD3055-4801-04-07 10x

Remove all foreign object

Before installing mounting bracket

perform rework as per RS1025 ✓

Install mounting bracket QB21304 B# 712440 with rivets QD3055-4807-0407
B# 0002384694

15-12-23

DAS
9
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		

Root Cause			FAULT CATEGORY		
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :			
Misidentified ☐	Past Due ☐				

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Page 2

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110 *110* Small Fab Small Fab	Memo SEE RS1025	0.00 0.00							<i>15/12/13</i> DAS 36 9-89
120 *120* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							<i>① 15.12.23</i> DAS 9 9-89
130 *130* Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo <i>fg039</i>	0.00 0.00							<i>1</i> <i>5m</i> <i>10/1/19</i>

update label by engraving "A" against Mod No.

DQA:

Date:

16.03.01



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed

Date:

16/02/18

Work Order update only ☐

Work Order: <u>136313</u>		DISPOSITION		AGAINST DEPARTMENT/PROCESS			
Part No. <u>D</u>		Rework ☒		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐
NCR No. <u>16-5591</u>		Scrap ☐		Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☒
		Use-as-is ☐		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
		Suspected Unapproved ☐		Large Fab ☐	Composite ☐	Supplier ☒	
Date: <u>15-12-13</u>		Step #: <u>110</u>		QTY Effective: <u>0</u>		MRB (QSI042) Approval	
Description Work Order Deviation				Disposition			
customer didn't provide us with correct rivets				replace rivets QD3055-4307-0407 with correct rivets from Dert stock CR3213-4-2 M123 936 10v			
				Completed By DAS 36 9-89 Lead hand / Supervisor Approval Verification DAS 9 9-89 DEC 23 2015			
				QC / QA Coordinator DAS Approval 9 9-89 DEC 23 2015			
Root Cause		FAULT CATEGORY					
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
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Required Date: 9/3/2015 Req'd Qty: 1.00 ***1***

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Reference: RMA RA111870

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

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Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	QC21- Final Inspection - Work Order Release	0.00							

140

QC

Memo

0.00

Quality Control

MCS

JAN 19 2016

MCS

JAN 19 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

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OTHER : _____					

Picklist Print

Friday, November 27, 2015 3:08:23 PM

Page 1

Work Order ID: 136313

136313

Parent Item: D350-822-011

D350-822-011

Parent Item Name: PA100 PUREair System for AS350/EC130

Start Date: 9/2/2015

Required Date: 9/3/2015

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 14.02.20 NEW ISSUE DD VERF:JLM IPP
REV:B 14.06.18 AS PER IIN REV.C DD VERF:JLM IPP REV:C
15.06.03 AS PER IIN REV.D DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D350-822-011

Manufactured

No

Each

5.0000

1

D350-822-011

PA100 PUREair System for AS350/EC130

Location

Loc Qty

Loc Code

Customer evaluation

4

121721

1

121722

1

121723

1

134021

1

FG033

1

135295

1

D4961-041

Manufactured

No

Each

3.0000

1

D4961-041

Tube Assembly

Location

Loc Qty

Loc Code

ST139

3

137235

3

DAS
27
9-89

JAN 13 2016

1 X 121720
MF
15-11-27

DAS
28
9-89

JAN 12 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

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RA111870

Received: August 27, 2015
Inspected: September 1, 2015

CUSTOMER: Pall Aerospace
CUSTOMER CONTACT: James Hardy
SHIPPED FROM: New Port Richey, Florida US

Instructions for RA111870 D350-822-011 B121720 CHG 001

- Customer is return D350-822-011, was used for display only
- Founding during inspection for completeness of kit
 - Damage on QB21304 (see picture)
 - Nuts on D4961-041 doesn't have holes for lock wire
 - Rest of kit is complete
- Scrap D4961-041 B11961 and replace
- With authorization and supplied parts from PALL replace QB21304 as showed on email
 - Drill out rivet QD3055-4801-04-07 10x
 - Remove all foreign object
 - Before installing mounting bracket perform rework as per RS1025
 - Install mounting bracket QB21304 B# 712440 with rivets QD3055-4807-0407 B# 0002384694

Time Estimate: 5 hours

Departments Required: Quality, stores, small fab

Pictures Attached: Yes

QTY INSPECTED: 1x D350-822-011 B121720 CHG 001

**THIS INSTRUCTION SHEET MUST BE
ATTACHED TO THE RESTOCKING
WORK ORDER AT ALL TIMES!!!!**

DQA: _____ Date: _____

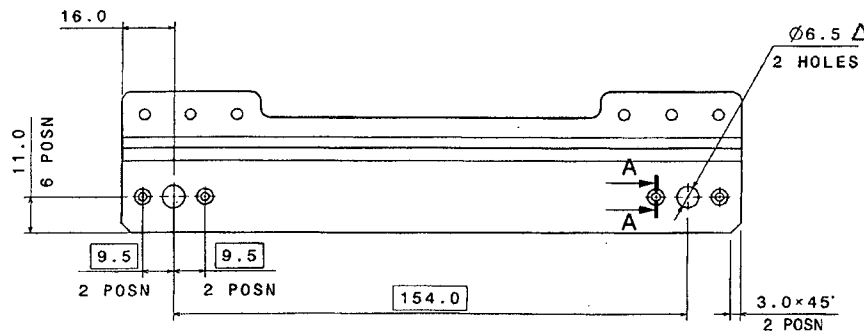
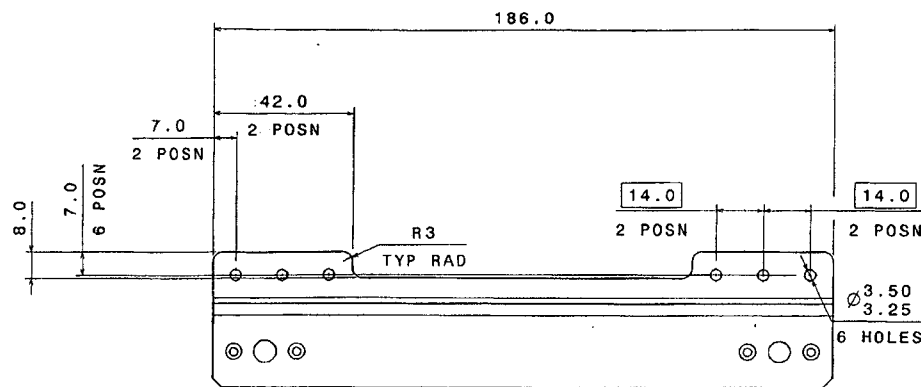


WORK ORDER NON-CONFORMANCE / UPDATE

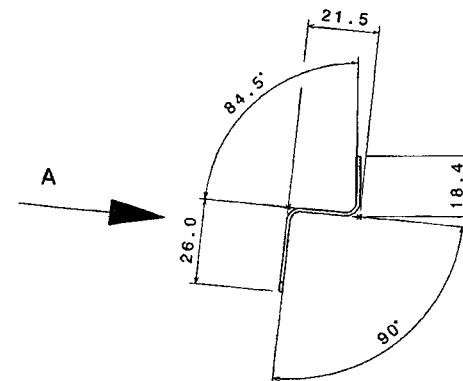
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Work Order update only ☐

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OTHER : _____					



VIEW ON ARROW A



SECTION VIEW A-A

SCALE: 5:1
TYP 4 POSN

NOTES:

1. MATERIAL: ALUMINIUM ALLOY L113-T6X19 SWG (1.0mm).
2. INTERNAL BEND RADII 3.0mm.
3. REMOVE ALL BURRS AND SHARP EDGES.
4. RIVET HOLES TO COMPLY WITH QD1028.
5. UNLESS OTHERWISE STATED ALL POSITIONAL TOLERANCE OF HOLES: ± 0.34
6. FLAT PATTERN OUTSIDE BORDER
7. FINISH: CHROMIC ANODISE TO DEF STAN 03-24.
8. PRIME USING REFS 01-03 IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS TO QD 3088.

PART MARK
TO QD5016 1 & 4

REF	PART NUMBER	QTY	DESCRIPTION	MATERIAL/REMARKS
01	QD3088-133	A/R	PRIMER EPOXY PR143	---
02	QD3088-134	A/R	CATALYST 143	---
03	QD3088-135	A/R	THINNERS T17	---

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---	--	--	---	---	---	---

RA111870

Received: August 27, 2015
Inspected: September 1, 2015

CUSTOMER: Pall Aerospace
CUSTOMER CONTACT: James Hardy
SHIPPED FROM: New Port Richey, Florida US

Instructions for RA111870 D350-822-011 B121720 CHG 001

- Customer is return D350-822-011, was used for display only
- Founding during inspection for completeness of kit
 - Damage on QB21304 (see picture)
 - Nuts on D4961-041 doesn't have holes for lock wire
 - Rest of kit is complete
- Scrap D4961-041 B11961 and replace
- With authorization and supplied parts from PALL replace QB21304 as showed on email
 - Drill out rivet QD3055-4801-04-07 10x
 - Remove all foreign object
 - Before installing mounting bracket perform rework as per RS1025
 - Install mounting bracket QB21304 B# 712440 with rivets QD3055-4807-0407 B# 0002384694

Time Estimate: 5 hours

Departments Required: Quality, stores, small fab

Pictures Attached: Yes

QTY INSPECTED: 1x D350-822-011 B121720 CHG 001

**THIS INSTRUCTION SHEET MUST BE
ATTACHED TO THE RESTOCKING
WORK ORDER AT ALL TIMES!!!!**

RA111870

Received: August 27, 2015
Inspected: September 1, 2015

CUSTOMER: Pall Aerospace
CUSTOMER CONTACT: James Hardy
SHIPPED FROM: New Port Richey, Florida US

Instructions for RA111870 D350-822-011 B121720 CHG 001

- Customer is return D350-822-011, was used for display only
- Founding during inspection for completeness of kit
 - Damage on QB21304 (see picture)
 - Nuts on D4961-041 doesn't have holes for lock wire
 - Rest of kit is complete
- Scrap D4961-041 B11961 and replace
- Will need to get authorization from PALL for instruction for fixing QB21304

Time Estimate: N/A

Departments Required: Quality, stores

Pictures Attached: Yes

QTY INSPECTED: 1x D350-822-011 B121720 CHG 001

**THIS INSTRUCTION SHEET MUST BE
ATTACHED TO THE RESTOCKING
WORK ORDER AT ALL TIMES!!!!**



Sender: Pall Corporation
Andrew Head / Faye Heard
Cardrew Industrial Estate

Cornwall
Phone: 01209 884234 / 4342
Fax: 01209 884247
TR15 1SS Redruth
United Kingdom
Sender's VAT No: GB107772467

Date: 28.09.2015

PROFORMA INVOICE

Invoice Number: ATS31363

Delivery to: DART AEROSPACE LTD
JENNIFER RENWICK/LINDA LACELLE
ABERDEEN STREET 1270

Billed To: DART AEROSPACE LTD
Contact: JENNIFER RENWICK/LINDA LACELLE
ABERDEEN STREET 1270

Ontario HAWKESBURY K6A1K7

Ontario HAWKESBURY K6A1K7

Canada

Canada

Phone: 1 800 556 4166

Phone: 1 800 556 4166

Fax:

Fax:

Receiver's VAT No:

VAT No:

Full Description of Goods	Qty	Unit Value	Subtotal Value	Unit Net Weight	Country of Manufacture/ Origin	Comm. Code
FILTRATION EQUIPMENT	1	150.00	150	0.5	United Kingdom	84213920
			Total Declared Value: 150.00 GBP		Total Net Weight: 0,5 kg(s)	
			Total Unit(s): 1		Total Gross Weight: 0,7 kg(s)	

Type of Export : permanent
Reason for Export : PURCHASE ORDER MFY508
0

Currency Code : GBP
Terms of Trade : DAP / HAWKESBURY
City Name of liability :

Signature: Andrew Head / Faye Heard

Airwaybill Number: 7840539431



Company Stamp: Pall Corporation
TR15 1SS Redruth



For the attention of: Patrick Smith,

DART AEROSPACE LTD.

1270 Aberdeen St
HAWKESBURY
Canada.
ON K6A 1K7,

Pall Aerospace

A Division of Pall Europe Limited
Cardrew Industrial Estate
Redruth
Cornwall
TR15 1SS
UK

00 44 (0)1209 884200 **phone**

00 44 (0)1209 884310 **fax**

Advice to Ship No. 31363

--- Status: Issued ---

Raised by:	Paul C. Wills - on - 28/09/2015		
Comments:	Ref Tom Clarke Returned D350-822-011		
Country of Origin:*	UK	Value for Customs:*	£150.00
Export Licence Req'd:*	No	Licence Number:*	N/A
Hazardous Material:*	No	MSDS Enclosed:*	N/A
Release Note Req'd:*	No	CAR No.:*	
Special Transport Instructions (if appl):			

	Purchase Order No.	Part No. / Drg No.	Description	Batch/ Serial No.	Qty Desp'd	Price Ea £	Line Total £
1	MFY5080	QB21304 PART SUB ASSEMBLY	Bracket sub assembly		1.00	£150.00	£150.00
2							
3							
4							
5							
6							
7							
8							
9							
10							
11							
12							
13							
14							
15							
						TOTAL	£150.00

Carrier Details (if applicable)

Carrier Name:

Carrier Consignment No:

EXPRESS WORLDWIDE

WPX

DHL

IntraShip (7.1) / *17-1409*

From Pail Corporation
Andrew Head / Faye Heard 01209 884234 / 4342
Cardrew Industrial Estate
Cornwall
TR15 1SS Redruth
GB United Kingdom

Origin
EXT

To DART AEROSPACE LTD
JENNIFER RENWICK/LINDA LACELLE
ABERDEEN STREET 1270

Phone:
1 800 556 4166

K6A1K7 HAWKESBURY
Ontario
CA Canada

CA-YOW-YRO

C

Day

Time

Ref code AT531363

Piece Weight: 0.7 kg

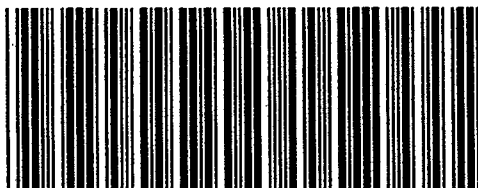
Piece

Account No 186318258

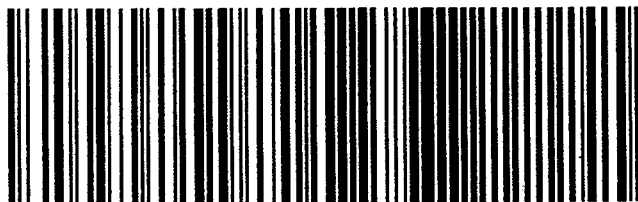
Pickup date: 2015-09-28

1/1

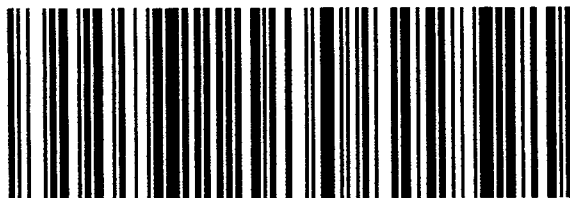
Content / Commerce Control Statement / RC
FILTRATION EQUIPMENT



WAYBILL 78 4053 9431



(2L)CAK6A1K7+48000001



(J)JD01 3054 7887 6921 2794

RA111870

15/10/11